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Canada

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D4435-041
Job Sheet 197643



Part No: D4435-041

Job Qty: 4 pcs

Part Name: Bracket Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/11/19

Job Tracking No:

Due Date: 8/20/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: D4435 REV.C IPP REV:B 12.03.06 AS PER DWG REV.B DD VERF:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	4 pcs		8/20/19	0.02	0.28	Waterjet - Flow		JRB 9/11/19
110	QC 2	4 pcs		8/20/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

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Container No: S212695

Part: D4435 - 041

Job No: 197643

Serial No/Batch: S212695

Revision: C

Inspector:

Exp Date:

Instructions: Various STC's

Date: 11/01/19

Plex 7/11/19 1:44 PM Dart.lajeunesse.marie

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

120 QC 8

4
pcs

8/20/19

0.00 0.00

JRB 9/11/19

QC 2 - 65

QC 2 - 5

QC 2 - 71

QC 2 - 73

QC 2 - 69

QC 8 - 12

QC 8 - 14

QC 8 - 17

QC 8 - 20

QC 8 - 25

QC 8 - 3

QC 8 - 32

QC 8 - 33

QC 8 - 35

QC 8 - 39

QC 8 - 4

QC 8 - 44

QC 8 - 45

QC 8 - 49

QC 8 - 58

QC 8 - 8

QC 8 - 9

QC 8 - 68

QC 8 - 67

QC 8 - 1 (A)

QC 8 - 47

QC 8 - 40

QC 8 - 52

QC 8 - 23

QC 8 - 57

SEP 12 2019

40
9-08

130 Handfinish - 1-1 Chemical- B4B

4
pcs

8/20/19

0.00 0.14

Handfinish - 1 - 1 - B4B

Handfinish - 1 - 2 - B4B

Handfinish - 1 - 3 - B4B

Handfinish - 1 - 4 - B4B

Handfinish - 1 - 5 - B4B

Handfinish - 1 - 6 - B4B

Handfinish - 1 - 7 - B4B

Handfinish - 1 - 8 - B4B

Handfinish - 1 - 9 - B4B

Handfinish - 1 - 10 - B4B

Handfinish - 1 - 11 - B4B

Handfinish - 1 - 12 - B4B

Handfinish - 1 - 13 - B4B

Handfinish - 1 - 14 - B4B

Handfinish - 1 - 15 - B4B

Handfinish - 1 - 16 - B4B

Handfinish - 1 - 17 - B4B

Handfinish - 1 - 18 - B4B

Handfinish - 1 - 19 - B4B

Handfinish - 1 - 20 - B4B

SEP 13 2019

135 QC 7	4 pcs	8/20/19	0.00 0.00	Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
				QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	BL 17-9-13
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
				QC 7 - 61	
				QC 7 - 81	
140 Powdercoat - 4 Black Sand - B4B	4 pcs	8/20/19	0.00 0.14	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	BL 19-9-13
				Powdercoat - 4 - B4B	
START: 10:55 OUT: 3:00 FINISH: 11:28					
150 QC 3	4 pcs	8/20/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	

DAS
30
9-89

NOV 1 20

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DAS
30
9-89

NOV 1 2019

160 Small Fab - 2 - B4B

4
pcs

8/20/19

0.00 0.54

QC 3 - 61

QC 3 - 81

Small Fab - 1 - B4B

Small Fab - 2 - B4B

Small Fab - 3 - B4B

Small Fab - 4 - B4B

Small Fab - 5 - B4B

Small Fab - 6 - B4B

Small Fab - 7 - B4B

NOV 01 2019

170 QC 5

4
pcs

8/20/19

0.00 0.00

QC 5 - 10

QC 5 - 12

QC 5 - 17

QC 5 - 18

QC 5 - 19

QC 5 - 22

QC 5 - 24

QC 5 - 3

QC 5 - 43

QC 5 - 49

QC 5 - 51

QC 5 - 58

QC 5 - 68

QC 5 - 9

QC 5 - 50

QC 5 - 30

QC 5 - 40

QC 5 - 61

QC 5 - 81

DAS
NOV 05 2019 68
9-89

190 Packaging 3-1 - Stock - B4B

4
pcs

8/20/19

0.00 0.00

Packaging 3 - 1 - B4B

Packaging 3 - 2 - B4B

Packaging 3 - 3 - B4B

Packaging 3 - 4 - B4B

Packaging 3 - 5 - B4B

Packaging 3 - 6 - B4B

Packaging 3 - 7 - B4B

Packaging 3 - 8 - B4B

Packaging 3 - 9 - B4B

Packaging 3 - 10 - B4B

Packaging 3 - 11 - B4B

Packaging 3 - 12 - B4B

Packaging 3 - 13 - B4B

Packaging 3 - 14 - B4B

Packaging 3 - 15 - B4B

Packaging 3 - 16 - B4B

Packaging 3 - 17 - B4B

Packaging 3 - 18 - B4B

Packaging 3 - 19 - B4B

Packaging 3 - 20 - B4B

Packaging 3 - 21 - B4B

Packaging 3 - 22 - B4B

Packaging 3 - 23 - B4B

Packaging 3 - 24 - B4B

Packaging 3 - 25 - B4B

Packaging 3 - 26 - B4B

Packaging 3 - 27 - B4B

Packaging 3 - 28 - B4B

Packaging 3 - 29 - B4B

Packaging 3 - 30 - B4B

Packaging 3 - 31 - B4B

STOPS F

Oscar

23

200 QC 21 - SA	4 pcs <u>23</u>	8/20/19	0.00 0.00	Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				QC 21 - SA - 21	✓
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op 100 - 1-Cut D4435-1 as per Dwg Dwg Rev: C Prog Rev: C 2-Deburr if necessary

Descriptions: 110 - QC2 Waterjet-3 (QC2- Inspect parts off machine FAI/FAIB)
 120 - QC8-4 (QC8- Inspect parts - second check)
 130 - HandFinish1 (Chemical Conversion Coat per QSI005 4.1)
 135 - QC7-3 (QC7-Inspect Chemical Conversion Coat)
 140 - Powdercoat4 (Black Sandtex(Ref:4.3.5.7) per QSI005 4.3) START TIME: _____ OVEN TEMPERATURE: _____
 FINISH TIME: _____
 150 - QC3 (QC3- Inspect Part Finish)
 160 - Small Fab-6 (Small Fab) 1- Cut rubber seal at 3.50" 2-Glue rubber seal to bracket as per dwg (SHEET 1, NOTE 8)
 170 - QC5 (QC5- Inspect part completeness to step on W/O)
 190 - Packaging3-2 (Identify as per dwg & Stock Location: _____)
 200 - QC21 (QC21- Final Inspection - Work Order Release)

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.040	6061-T6 .040 Sheet	.1720 sf (.043 ea)	100-Waterjet - Flow - 1	
D4441-1	Rubber Seal	1.1664 ft (.2916 ea)	160-Small Fab - 2 - B4B	<u>5204169</u> <u>6-7863</u> <u>5092/67</u>

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M6061T6S.040	0	401	0
160-Small Fab - 2 - B4B	D4441-1	1	322	0

Specifications could not be found.

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FIRST ARTICLE INSPECTION CHECKLIST

**DAS
40
9-84**

Preliminary Approval:	
Date:	

[illegible]

Entered: _____

Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

DISPOSITION Rework ☐ ☐ ☐ Scrap ☐ ☐ ☐ Use-as-is ☐ ☐ ☐		DEPARTMENT/PROCESS Skid-tube Machining Large Fab ☐ ☐ ☐ Cross tube Small Fab Finishing ☐ ☐ ☐ Eng. (Non-AW) Prod. Eng. Coord. Rec/Store/Packaging ☐ ☐ ☐		Engineering Water Jet Supplier Quality ☐ ☐ ☐ ☐ ☐	
Job: _____ Part No. _____ Date: _____		Sequence #: _____ QTY Affected: _____		MRB (QS1042) _____	
Description Work Order Deviation		Disposition			
Root Cause Operator ☐ ☐ ☐ ☐ ☐ Manufacturing Process ☐ ☐ ☐ ☐ ☐ Equip/Tooling ☐ ☐ ☐ ☐ ☐ Handling/Preservation ☐ ☐ ☐ ☐ ☐ Material ☐ ☐ ☐ ☐ ☐ Product Improvement ☐ ☐ ☐ ☐ ☐ Process Improvement ☐ ☐ ☐ ☐ ☐ Human Factors ☐ ☐ ☐ ☐ ☐		FAULT CATEGORY Contamination ☐ ☐ ☐ ☐ ☐ Misaligned/off center BOM/Route Broken/Damage/Defect Incomplete/Unclear Instructions Drill Holes Fit/Function Pressure/Forced Bending Crushing Cracks Crimp/Kink/Ripple/Wave/Twist Marks/Chatter Mislabeled Power Loss/Surge Folio/Program Grain Direction Weld Wrong Stock Pulled Out of Sequence Off-set/Set-up Positioned Wrong Outside Tolerance Drawing Finish Part Lost/Missing Misread			
Completed By		Lead hand / Supervisor			
QC / QA Coordinator		_____			